



FOSHAN ZEREN PRECISION CASTING CO., LTD.

Address: No.4, Xinzhaoh Industrial Park, Shishan, Nanhai, Foshan, Guangdong, China

Contact: Doris Lyu Tel: +86 15875760497(Whatsapp, Skype, Wechat)

Email: casting@gdzeren.com/ gdzrcasting@gmail.com

Website: www.zr-investmentcasting.com

fszeren.en.alibaba.com, gdzeren.com/en

TECHNICAL INFORMATION

DIMENSION TOLERANCE

Liner Tolerance (Refer to German Investment Casting Tolerance Standards VDG Merkblad P690)

Nominal Dimension		Length, Width, Height						Center Line	
		D1		D2		D3		D1	D2
> From	≤ To	Tolerance	Field	Tolerance	Field	Tolerance	Field	Tolerance	Tolerance
0	6	±0.10	0.20	±0.08	0.16	±0.06	0.12	±0.25	±0.16
6	10	±0.12	0.24	±0.10	0.20				
10	14	±0.15	0.30	±0.12	0.24	±0.09	0.18		
14	18	±0.2	0.40	±0.14	0.28				
18	24	±0.25	0.50	±0.17	0.34	±0.12	0.24	±0.32	±0.20
24	30	±0.30	0.60	±0.20	0.40	±0.14	0.28		
30	40	±0.37	0.74	±0.25	0.50	±0.17	0.34	±0.50	±0.30
40	50	±0.44	0.88	±0.30	0.60	±0.20	0.40		
50	65	±0.52	1.04	±0.38	0.76	±0.23	0.46	±0.71	±0.45
65	80	±0.60	1.20	±0.46	0.92	±0.27	0.54		
80	100	±0.68	1.36	±0.53	1.06	±0.30	0.60	±0.91	±0.60
100	120	±0.76	1.52	±0.60	1.20	±0.33	0.66		
120	140	±0.84	1.68	±0.65	1.30	±0.36	0.72	±1.15	±0.85
140	160	±0.92	1.84	±0.72	1.44	±0.38	0.76		
160	180	±1.02	2.04	±0.80	1.60	±0.42	0.84		
180	200	±1.12	2.24	±0.88	1.76	±0.43	0.86	±1.80	±1.00
200	225	±1.28	2.56	±0.95	1.90	±0.47	0.94		
225	250	±1.44	2.88	±1.05	2.10	±0.51	1.02		
250	280	±1.64	3.28	±1.15	2.30	±0.56	1.12	±2.20	±1.25
280	315	±1.84	3.68	±1.25	2.50	±0.63	1.26		
315	355	±2.10	4.20	±1.40	2.80	±0.71	1.42	±2.60	±1.60
355	400	±2.40	4.80	±1.60	3.20	±0.80	1.60		

D1 General dimension tolerance

D2 Applicable to important dimension requiring close tolerances

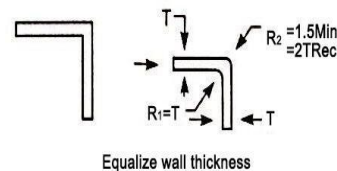
D3 Premium tolerance require additional operations at extra cost only applied to a few special dimensions

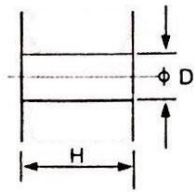
Angle Tolerance $\pm 0.5^\circ$ to $\pm 1^\circ$

Straightness $\leq 0.005^\circ$ per inch

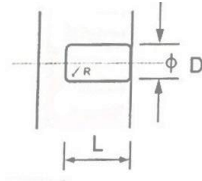
CASTING CAPABILITY

Depth of casting hole

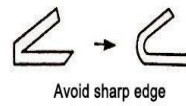




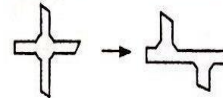
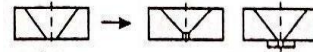
Through Hole
 $D \leq 7\text{mm}$ $H \leq 2D$
 $D > 7\text{mm}$ $H \leq 3D$
 $D > 7\text{mm}$ $H \leq 4D$
 $D_{\text{min}} = 2\text{mm}$



Blind Hole
 $D \leq 7\text{mm}$ $H \leq 1D$
 $D > 7\text{mm}$ $H \leq 1.5D$
 $D > 7\text{mm}$ $H \leq 2D$
 $D_{\text{min}} = 2\text{mm}$



Avoid sharp change in thickness



Avoid cross section

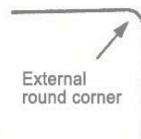
The scope can be enlarged by the use of pre-formed ceramic cores at additional cost, only economical for large quantities

Minum wall thickness: 2mm (1mm for small area)

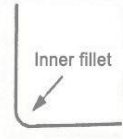
Radius of Rounds and fillets

Surface Roughness: Ra3.2

Casting Weight: 5g-10Kg



$R \geq 0.3\text{mm}$



$R \geq 0.5\text{mm}$